

Work Order ID 133007

133007

Page 1

Friday, May 22, 2015 11:42:50 AM

Item ID: PB67-43001-13

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015 Start Qty: 1.00 **

Cust Item ID:

Required Date: 5/29/2015 Req'd Qty: 1.00 **

Customer:

Reference:

Approvals: Process Plan: mf Date: 5-5-27 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-13	Rev C

100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg 3- grind weld flush in area of PB67-43001-249 only 4- install helicol insert as per dwg								

1x CC 15-6-16

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

① 15-06-22

DAS
9
9-89

~~① 15-06-17~~

~~DAS
9
9-89~~

P.T.O.

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

① 15-06-17

DAS
9
9-89

DQA:

Date: 15/06/20



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/20

Work Order update only ☐

Work Order: 133007	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. PB67-43001-13		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 15-5150		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☒	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15-06-18	100	②	During inspection of PB67-43001-13 cracks was found on PB67-43001-67 P.C. welding / too much heat	S 15/06/18 a52042	Remove and scrap PB67-43001-67 B 111266 92092	15-6-22 Cpl CL 15-6-22		DAS 9 9-89 15-06-22
Doc/Data							PB67-43001-253 B <u>133228</u>			
Equip/Tooling							PB67-43001-254 B <u>133227</u>			
Handling/Pre							Replace PB67-43001-67 B <u>111266</u>			
Material							PB67-43001-253 B <u>116441</u>			
Operator	☒						PB67-43001-254 B <u>133227</u>			
Offset/Setup							Re use PB67-43001-255 and weld assembly as per drawing and QSI 004			
Process	☒									
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☒ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Friday, May 22, 2015 11:42:50 AM

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Setup Start *NS1*

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Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/29/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

N/A

DAS
9
9-89

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

M 111277

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET

START TIME: 2:40
OVEN TEMPERATURE: 320
FINISH TIME: 3:40

1 \$156.24 02 34 9-89

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

0

DAS
38
9-89

JUN 25 2015

Friday, May 22, 2015 11:42:50 AM

Item ID: PB67-43001-13

Accept

N900040100

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Revision ID:

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Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/29/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

ML5

JUN 2 5 2015

ME
15-6-25

Picklist Print

Friday, May 22, 2015 11:42:49 AM

Page 1

Work Order ID: 133007

133007

Parent Item: PB67-43001-13

PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per RevC EC verified by:DD

IPP RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67		Manufactured	No				Each	0.0000		1			
PR67-43001-67													
90° Blade Support Assembly													
PB67-43001-249		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-249													
Inner Tube Bushing													
PB67-43001-253		Manufactured	No			100	Each	2.0000	1	1			
PR67-43001-253													
Gusset													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				Mezz2	2								
				116441	2								
PB67-43001-254		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-254													
Gusset													
PB67-43001-255		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-255													
Inner Tube													
MS124780		Purchased	No			180	Each	80.0000	1	1			
MS124780													
HELICAL INSERT													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST260a	63								
				m128173	63								
				ST317	17								
				111064	17								

B92092 → 1x **

CC 15-6-16

B133229 → 1x **

CC 15-6-16

B133228 → 1x **

CC 15-6-16

B133227 → 1x **

CC 15-6-16

B133234 → 1x **

CC 15-6-16

**

CC 15-6-16

1x

Picklist Print

Friday, May 22, 2015 11:42:49 AM

Work Order ID: 133007

133007

Parent Item: PB67-43001-13

PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

180

Each

364.0000

8

8

MS27039-1-10

SCREW

DAB
27
9-89

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

239

m129541

239

ST285

84

m123522

2

m130358

72

m130388

10

NAS1149D0316J

Purchased

No

180

Each

369.0000

8

8

NAS1149D0316.J

Washer

DAB
27
9-89

Location

Loc Qty

Loc Code

GA

156

122151

156

ST270

213

M127956

213

NAS1149D0363J

Purchased

No

180

Each

2,186.000

8

8

NAS1149D0363.J

Washer

DAB
27
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

222

m128429

222

ST269

1395

m126319

9

m131618

386

m132317

1000

JUN 25 2015

Picklist Print

Page 3

Friday, May 22, 2015 11:42:49 AM

Work Order ID: 133007

133007

Parent Item: PB67-43001-13

PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-69

Manufactured No

180

Each

10.0000

1

1

PB67-43001-69

90 Degree Cover Plate

DAS

27

9-89

Location

Loc Qty

Loc Code

Mezz2

10

111761

10

180

Each

24.0000

1

1

PB67-43001-83

Manufactured No

PB67-43001-83

D-Pad Assembly, Short

DAS

27

9-89

JUN 25 2015

Location

Loc Qty

Loc Code

Mezz2

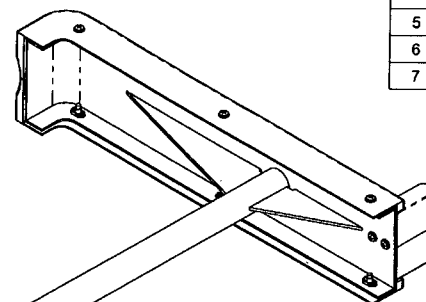
24

111757

24

8 7 6 5 4 3 2 1

ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER



00

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

mf
133007

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	b		DRAWING NO. REV. C	
CHECKED	[Signature]		B67-43001-13 SHEET 1 OF 2	
MFG. APPR.	[Signature]		TITLE SCALE	
APPROVED	[Signature]		AFT ADJUSTABLE BLADE SUPPORT ASSY NTS	
DE APPR.	N/A			
DATE	10.04.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

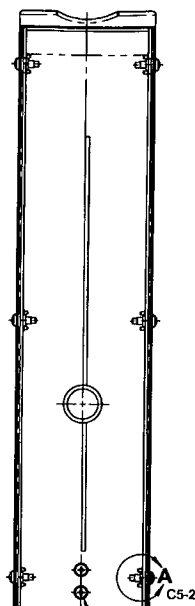


WORK ORDER NON-CONFORMANCE / UPDATE

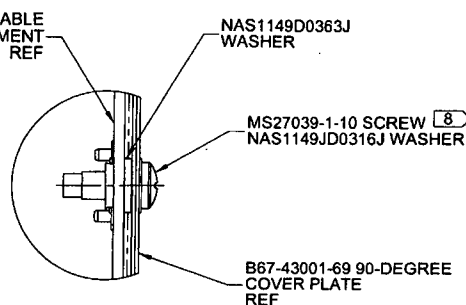
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER
2 PL [8]



SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-13W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-83
D-PAD ASSEMBLY, SHORT

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.21 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-13W AND B67-43001-83 TO B67-43001-69

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-13	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



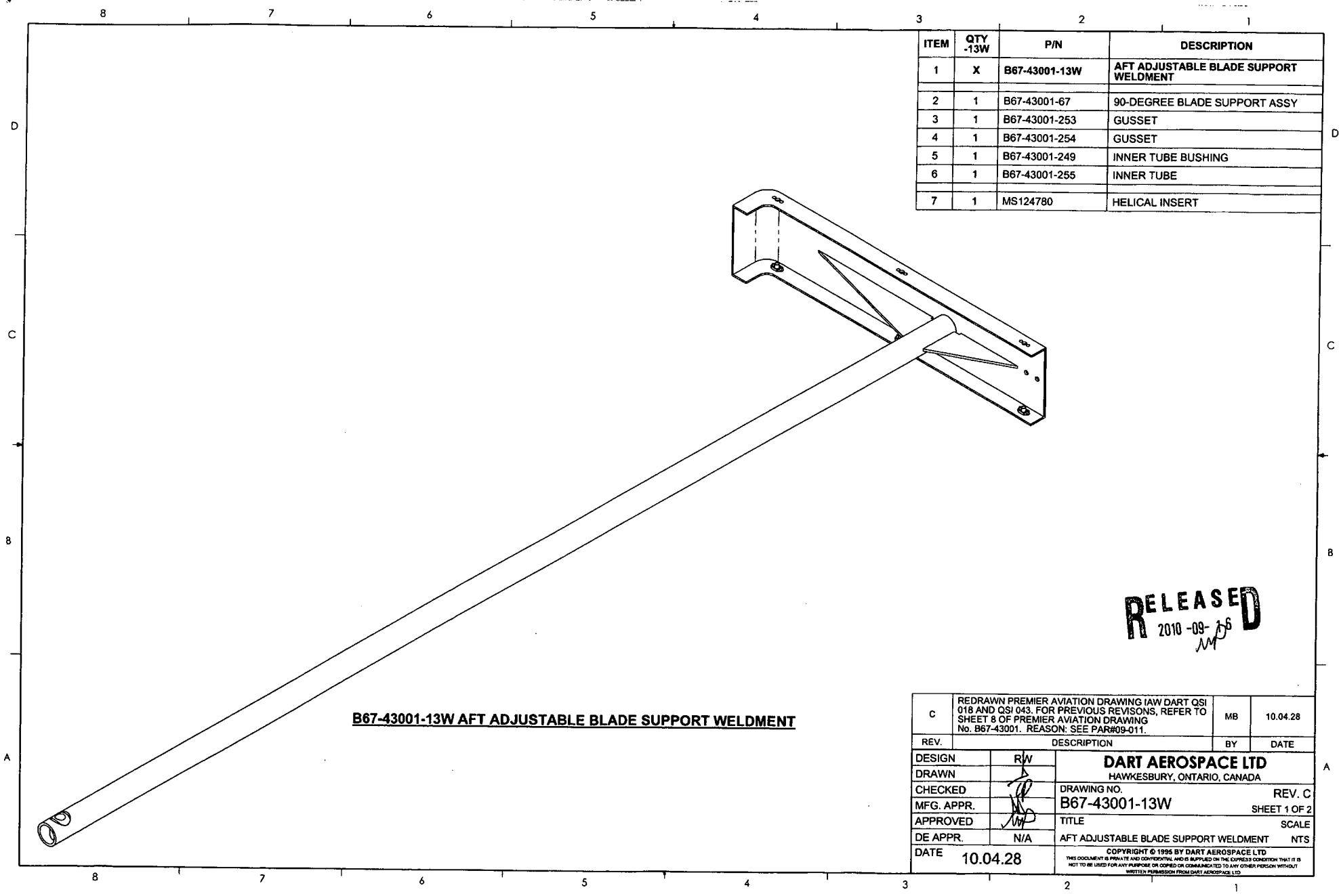
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐			



ITEM	QTY -13W	P/N	DESCRIPTION
1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-253	GUSSET
4	1	B67-43001-254	GUSSET
5	1	B67-43001-249	INNER TUBE BUSHING
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-15
MM

B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	TP	DRAWING NO. REV. C B67-43001-13W SHEET 1 OF 2	
CHECKED	JS	TITLE SCALE	
MFG. APPR.	MM	AFT ADJUSTABLE BLADE SUPPORT WELDMENT NTS	
APPROVED	N/A	DATE 10.04.28	
DE APPR.		COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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				Lead hand / Supervisor Approval Verification																																																																		
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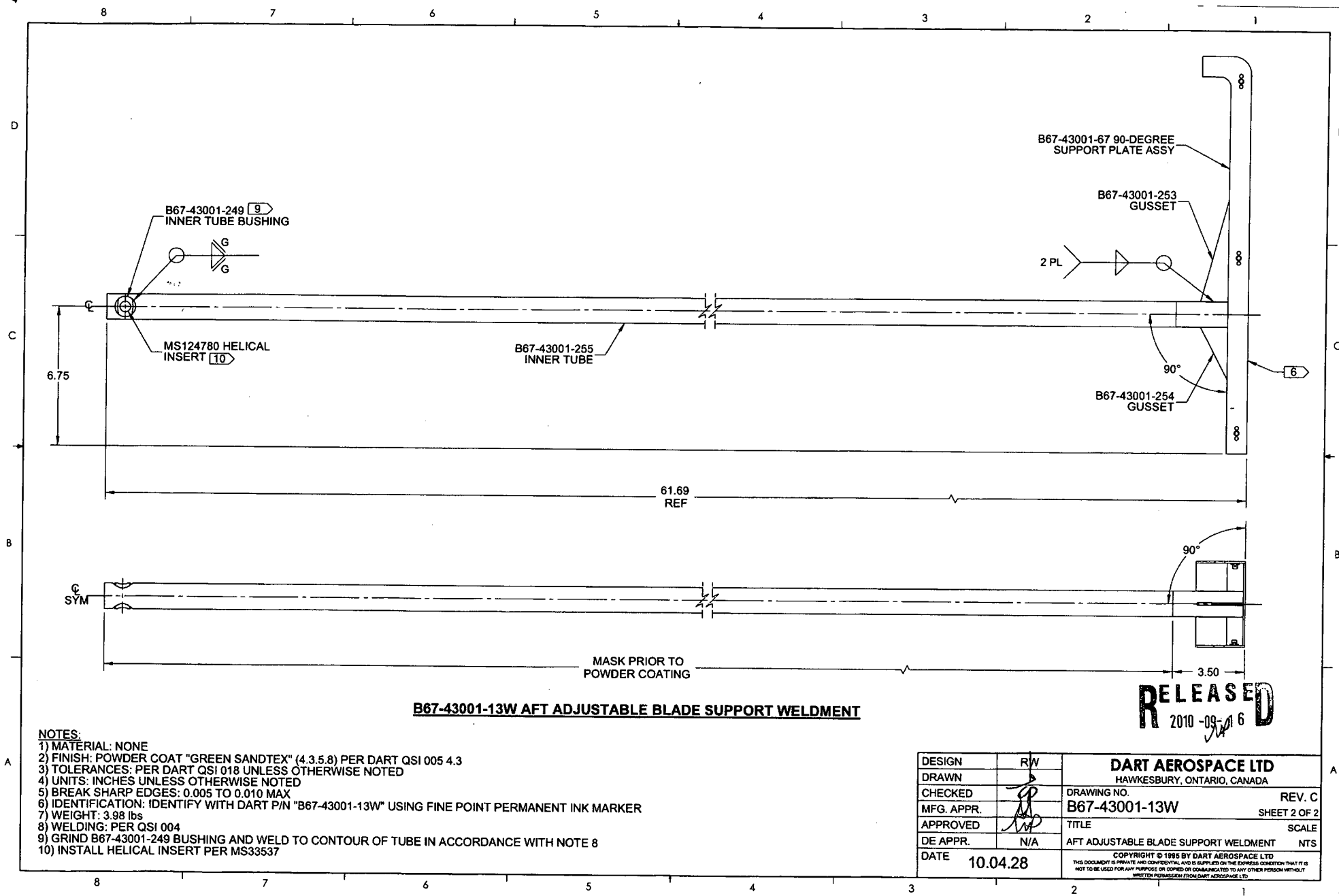
B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-13W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.98 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-13W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-09-16



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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